

4/02

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	20116
<b>Description:</b> Spacepod Hardware Kit 03.12.22 UP	<b>Part Number:</b>	K10018
-1 03.12.22 UP		
<b>Dwg:</b> D2174 Rev. C; D2174-041 Rev. C; D2175 Rev. C	<b>Qty:</b>	1 Kits
RF 03.04.30		Page 1 of 2

Step	Location	Procedure	By	Date	Qty								
1	DC	Issue Traveler <b>Note: K10018 Kit to be made in multiples of 7.</b> <b>(1) K10018 requires (2) D2174-041.</b> <b>(1) D2174-041 consists of (1) D2174-1 Web &amp; (2) D2175 Angle</b>		03.12.22	1								
2	MV	Cut blanks: (12.000" x 3.850") Material: 2024-T3 (QQ-A-250/5) 0.063" thick sheet (M2024T3S.063) <b>Use stack of 7</b> <b>Identify for D2174-1</b> Batch: _____											
3	MV	<b>Cut (2) blanks per (1) K10018 Kit</b> Cut blanks: (12.200" x 2.960") <b>grain along 2.960</b> Material: 2024-T3 (QQ-A-250/5) 0.063" thick sheet (M2024T3S.063) <b>Use stack of 7</b> <b>Identify for D2175</b> Batch: _____											
4	MV	Machine D2174-1 as per Folio FA097 and Dwg D2174-1 <b>Identify as D2174-1</b>											
5	QC2	Inspect parts as they come off the CNC machine											
6	MV	Deburr for measurement											
7	QC8	Second check											
8	MV	Machine D2175 as per Folio FA083 and Dwg D2175 <b>Identify as D2175</b>											
9	QC2	Inspect parts as they come off the CNC machine											
10	MV	Deburr for measurement											
11	QC8	Second check											
12	GA	Deburr D2174-1 and D2175 stacks											
13	GB	Form D2175 Angle as per Dwg D2175											
14	QC5	Inspect work to Step 13											
15	FP	Chemical Conversion Coat per QSI 005 4.1 and Dwg D2174-1 and D2175											
16	QC3	Inspect work to Step 15											
17	GA	Assemble D2174-1 and D2175 as per Dwg D2174-041 <b>Pick:</b> <table><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>23</td><td>MS20470AD4-6</td><td>Rivet</td><td>_____</td></tr></table> <b>Identify as D2174-041</b>	Qty	Part Number	Description	Batch	23	MS20470AD4-6	Rivet	_____			
Qty	Part Number	Description	Batch										
23	MS20470AD4-6	Rivet	_____										
18	QC5	Inspect work to Step 17											
19	FP	Powder Coat White (Ref: 4.3.5.1) as per QSI 005 4.3											
20	QC3	Inspect Powder Coat. Go to KP cell for packing.											

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: \_\_\_\_\_ Fault Category: \_\_\_\_\_ DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**NOTE:** Date & initial all entries  
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	20116
<b>Description:</b> Spacepod Hardware Kit	<b>Part Number:</b>	K10018
<b>Dwg:</b> D2174 Rev. C; D2174-041 Rev. C; D2175 Rev. C	<b>Qty:</b>	1 Kits
RF 03.04.30		Page 2 of 2

Step	Location	Procedure	By	Date	Qty																																																
21	KP	<p>Pick: Packing Kit (Note: D2174-041 is not on the BOM, but is in as material from steps 2 &amp; 3)</p> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>2</td><td>D2174-041</td><td>Web Assembly</td><td>B13732</td></tr><tr><td>1</td><td>D2985</td><td>Decal</td><td>B14160</td></tr><tr><td>8</td><td>A3235-020-935</td><td>Washer</td><td></td></tr><tr><td>16</td><td>AKS7-1032-130</td><td>Insert</td><td>M6087</td></tr><tr><td>8</td><td>AN3-3A</td><td>Bolt</td><td>M14149</td></tr><tr><td>8</td><td>AN3H4A</td><td>Bolt (or AN3H4)</td><td>M14149</td></tr><tr><td>36</td><td>AN525-10R7</td><td>Screw</td><td>M14149</td></tr><tr><td>8</td><td>AN960JD10</td><td>Washer</td><td>M13719</td></tr><tr><td>16</td><td>AN960JD10L</td><td>Washer</td><td>M13471</td></tr><tr><td>16</td><td>MS21042L3</td><td>Nut (or -3)</td><td>M14019</td></tr><tr><td>8</td><td>MS24694S67</td><td>Screw</td><td>M9750</td></tr></tbody></table>	Qty	Part Number	Description	Batch	2	D2174-041	Web Assembly	B13732	1	D2985	Decal	B14160	8	A3235-020-935	Washer		16	AKS7-1032-130	Insert	M6087	8	AN3-3A	Bolt	M14149	8	AN3H4A	Bolt (or AN3H4)	M14149	36	AN525-10R7	Screw	M14149	8	AN960JD10	Washer	M13719	16	AN960JD10L	Washer	M13471	16	MS21042L3	Nut (or -3)	M14019	8	MS24694S67	Screw	M9750	AKS4	04/1/06	1
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16	MS21042L3	Nut (or -3)	M14019																																																		
8	MS24694S67	Screw	M9750																																																		
22	QC4	Inspect Kit 100% for Completeness on the W/O		04-02-03	1																																																
23	ST	Identify and Stock		04-02-03	1																																																
24	AC	Cost / part 60.93	SJC	04-02-04	1																																																
25	DC	Close W/O 60.48 Inspect Level 21	KJ	04.02.05	1																																																

Rev	Date	Change	Revised By	Approved
A	03.03.26	New issue	KJ/RF	

**RELEASED**  
03.04.30

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#:\_\_\_\_\_ Fault Category:\_\_\_\_\_ DQA:\_\_\_\_\_ Date:\_\_\_\_\_

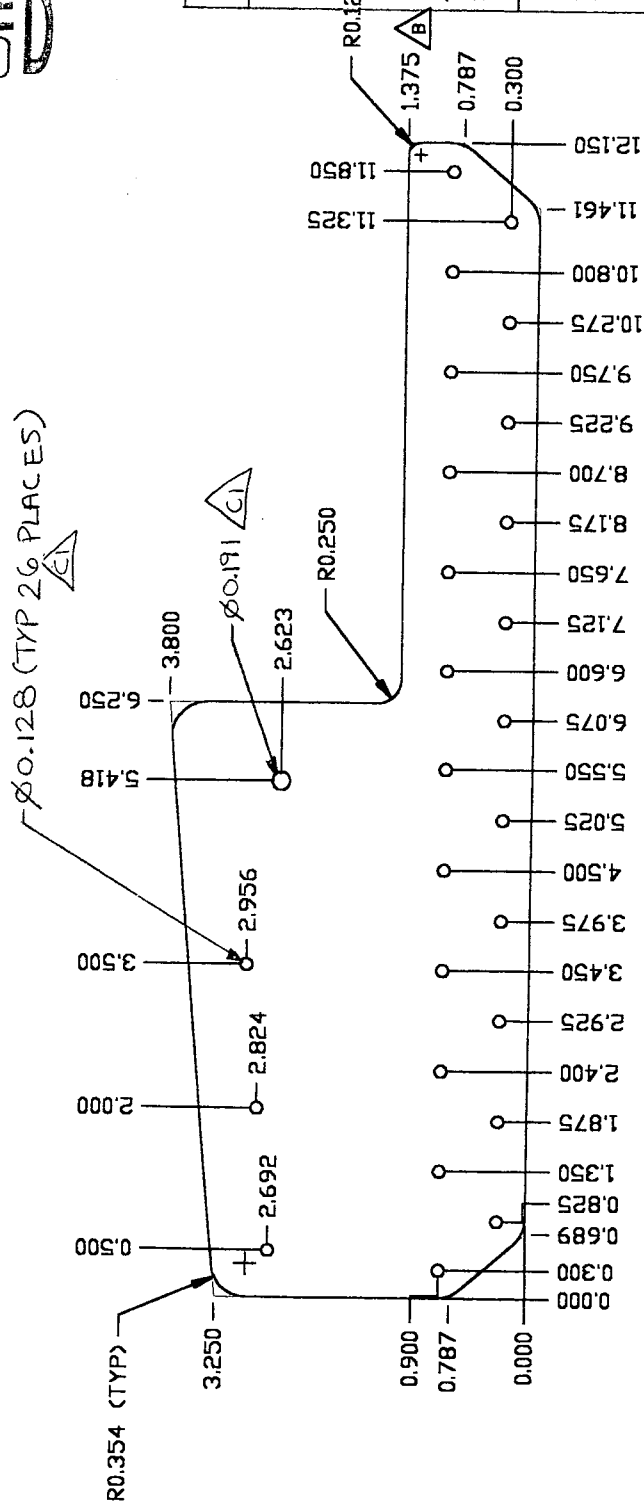
**NOTE:** Date & initial all entries  
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QA: N/C Closed: \_\_\_\_\_ Date:\_\_\_\_\_



DESIGN B WILLIAMS	DRAWN BY K HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED B.W.	APPROVED [Signature]	DRAWING NO. D2174-1	REV. # SHEET 1 OF 1
DATE 95:10:25	TITLE WEB		
B	96.01.18	RE-DRAWN CHANGED DIMENTION	
C	00.09.11	UPDATE FINISH SPEC. # CP	

RELEASED  
00.09.12 #



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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 20116

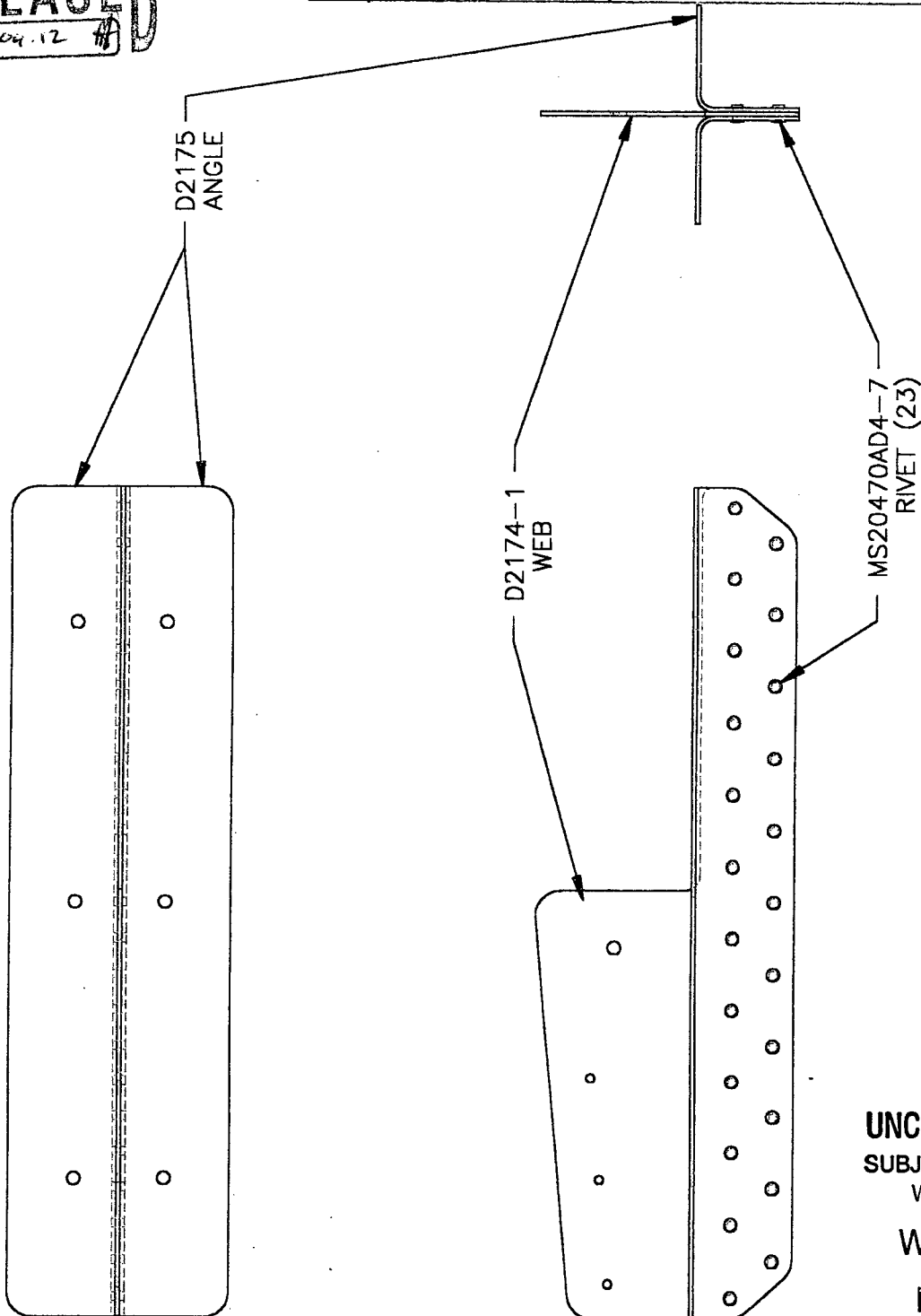
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4-1  
MATERIAL: 2024-T3 (QQ-A-250/5), 0.063 THICK

C1 01.02.22 ADD HOLE DIMENSIONS # CP



DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	K HAND	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. #
BW	[Signature]	D2174-041	00.07.06
DATE	TITLE		SHEET 1 OF 1
95:10:25	WEB ASSEMBLY		SCALE
B	96.01.18	RE-DRAWN	
C	00.09.11	UPDATE FINISH SPEC. [Signature] CP	

RELEASED  
00.04.12 [Signature]



MATERIAL: 2024-T3 (QQ-A-250/5), 0.063 THICK  
FINISH: ANODIZE CLEAR POWDER COAT WHITE PER DART QST 005 4.3.5.1

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SUBJECT  
WITH  
WORK  
NO. 20116

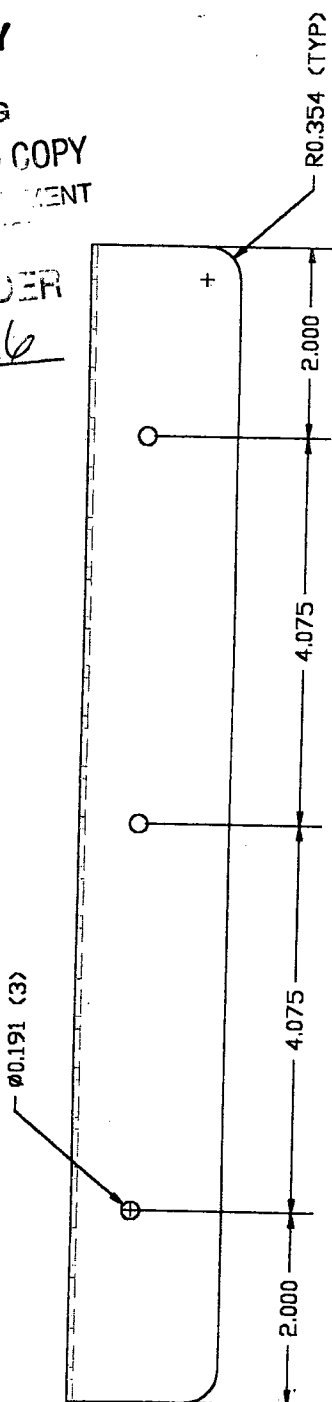


DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	K HAND	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. #
BW	[Signature]	D2175	
DATE	TITLE		SCALE
95:10:25	ANGLE		
B	96.01.18	CHANGED DIMENTION	
C	00.09.11	UPDATE FINISH SPEC. [Signature] CP	

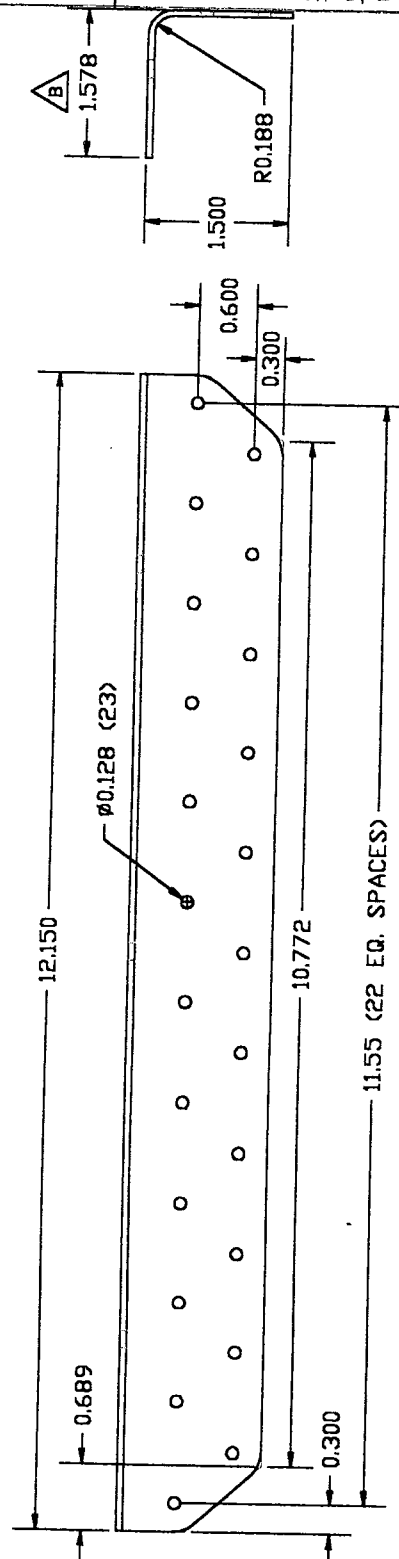
RELEASED  
00.09.12

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SUBJECT TO REVISION  
WITHOUT NOTICE  
WORK ORDER  
NO. 20116

C1 00.10.20 ADD GRN-W DIRECTION



GRAIN  
DIRECTION  
CP 00.10.20 (NUR 358)  
CP 00.10.20



MATERIAL: 2024-T3 (QQ-A-250/5), 0.063 THICK  
FINISH: ANODIZE CLEAR  
CHEMICAL CONVERSION COAT PER DART  
QST 005 4.1

## Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Dec 22, 2003  
04:13 pm

Work Order No	: 0020116	Department Code:	
Project Name	: K10018	Burden Flags	: NNNNNNNN
Project For	: WK401	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: K10018	Invoice Number	:
Description	: Spacepod Hardware Kit	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 1	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 12-22-03		
Est Finish Date	: 01-09-04	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
=====	=====	=====	=====	=====	=====
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
=====	=====	=====	=====		
Burden	: 0.00	0.00	0.00		
=====	=====	=====	=====		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00